

5    **I CLAIM:**

1.    A polymerizable resin material comprising: a monomer comprised of bisphenol A ethoxylate (1 to 4) dimethacrylate, about 70 to about 90%, by weight; and benzylmethacrylate, about 10 to about 20%, by weight; and, optionally, one or more stabilizing monomers,  
10    which polymerizable resin material, when exposed to heat or visible and/or UV light for a suitable period of time, is cured.

2.    The polymerizable resin material of claim 1, wherein the stabilizing monomer comprises at least one of trimethylolpropane  
15    trimethacrylate, about 1 to about 10%, by weight; isobornyl methacrylate, about 1 to about 10%, by weight; ethoxylate nonyl phenol acrylate, about 1 to about 10%, by weight; ethoxylate monyl phenol, about 1 to about 10%, by weight; and/or 2-phenoxyethyl methacrylate esters, about 1 to about 10%, by weight.

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3.    The polymerizable resin material of claim 1, further comprising at least one photochromatic dye.

4.    The polymerizable resin material of claim 1, further  
25    comprising at least one photoinitiator material.

5.    The polymerizable resin material of claim 1, further comprising at least one dye stabilizer material.

6. The polymerizable resin material of claim 1, further comprising at least one UV stabilizer material.

7. The polymerizable resin material of claim 1, wherein the  
5 resin material is exposed to light in the range of about 368 to about 580 nm.

8. The polymerizable resin material of claim 7, wherein the  
10 resin material is cured for a period of time of about two and a half minutes or less.

9. The polymerizable resin material of claim 1 comprising: the lens composition for forming photochromatic lens comprises bisphenol A ethoxylate (1 to 4) dimethacrylate, about 70 to 90%, by weight;  
15 benzylmethacrylate, about 10 to about 20%, by weight, and one or more of the following stabilizing monomers selected from the group of: trimethylolpropane trimethacrylate, about 1 to about 20%, by weight; isobornyl methacrylate, about 1 to about 20%, by weight; ethoxylate nonylphenol, about 1 to about 20%, by weight; 2-phenoxyethyl  
20 methacrylate-esters, about 1 to about 20%, by weight; ethoxylate nonyl phenol acrylate, about 1 to about 20%, by weight; optionally one or more photochromatic dyes, about .001 to about .0001%, by weight; optionally one or more UV stabilizers, about 1 to about .1%, by weight; optionally one or more dye stabilizers, about .1 to .00001%, by weight;  
25 optionally one or more silane materials, about 1 to 5%, by weight; and, optionally, one or more photoinitiators, about 1 to about 5%, by weight.

10. The polymerizable resin material of claim 9, comprising: bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight;  
30 benzylmethacrylate, about 8.58%, by weight; trimethylolpropane

trimethacrylate, about 2.6%, by weight; UV stabilizer, about .19%, by weight; Chromtech Blue 475, about .004%, by weight; Chromtech PH 20, about .0096%, by weight; Chromtech PH 8, about .00096%, by weight; silane, about 2.9%, by weight; and photoinitiator, about .18%,  
5 by weight.

11. The polymerizable resin material of claim 9, comprising: bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight; benzylmethacrylate, about 8.58%, by weight; trimethylolpropane  
10 trimethacrylate, about 2.6%, by weight; UV stabilizer, about .19%, by weight; Chromtech Orange PH-2458, about .004%, by weight; Chromtech PH 20, about .0096%, by weight; Chromtech PH 8, about .00096%, by weight; silane, about 2.9%, by weight; and UV stabilizer, about .18%, by weight.

12. The polymerizable resin material of claim 9, comprising: bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight; benzylmethacrylate, about 8.58%, by weight; ethoxylate nonylphenol, about 2.6%, by weight; UV stabilizer, about .19%, by weight;  
15 Chromtech Purple 293, about .004%, by weight; Chromtech PH 20, about .0096%, by weight; Chromtech PH 8, about .00096%, by weight; silane, about 2.9%, by weight; and photoinitiator, about .18%, by weight.

13. The polymerizable resin material of claim 9, comprising: bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight; benzylmethacrylate, about 8.58%, by weight; ethoxylate nonylphenol, about 12.6%, by weight; UV stabilizer, about .19%, by weight;  
25 Chromtech Yellow 339, about .004%, by weight; Chromtech PH 20, about .0096%, by weight; Chromtech PH 8, about .00096%, by weight;  
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silane, about 2.9%, by weight; and photoinitiator, about .18%, by weight.

14. The polymerizable resin material of claim 9, comprising:  
5 bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight;  
benzylmethacrylate, about 8.58%, by weight; UV stabilizer, about .19%,  
by weight; Chromtech Green 572, about .002%, by weight; Chromtech  
Blue 475, about .002%, by weight; Chromtech PH 20, about .0096%,  
by weight; Chromtech PH 8, about .00096%, by weight; silane, about  
10 2.9%, by weight; and photoinitiator, about .36%, by weight.

15. A method for making a plastic lens comprising  
providing a front mold having a reflective, non-visible  
and non-ultraviolet (UV) absorptive inner surface;  
15 providing a back mold which is light transmissive;  
disposing the front mold and the back mold in a light  
transparent gasket, the gasket defining a lower inner edge for removably  
sealing the front mold to the gasket, the gasket further defining an upper  
inner edge for holding the back mold in a spaced apart relationship to the  
20 lower inner edge, the space between the upper and lower inner edges  
defining a lens forming cavity when the front mold and the back mold are  
positioned in the gasket;  
the lower inner edge of the gasket extending in a  
radially inward direction around an inner surface of the gasket, the lower  
25 inner edge having an upper surface which is in a spaced apart  
relationship to the upper inner edge wherein the front mold is removably  
sealed within and is held in position in the gasket by the lower inner  
edge;  
dispensing a predetermined quantity of a curable lens  
30 forming nonphotoinitiating resin material in the lens forming cavity, the

resin material comprising bisphenol A ethoxylate (1 to 4) dimethacrylate, about 70 to about 90%, by weight; and benzylmethacrylate, about 10 to about 20%, by weight; and, optionally, one or more stabilizing monomers; which resin material cures when exposed to heat or visible and/or UV light; and,

exposing the dispensed resin material in the lens forming cavity to a source of heat visible and/or UV light for a predetermined length of time at a predetermined intensity to cure the resin material without the need for cooling the resin material.

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16. The method of claim 15, in which the stabilizing monomers are selected from the group of: trimethylolpropane trimethacrylate, about 1 to about 10%, by weight; isobornyl methacrylate, about 1 to about 10%, by weight; ethoxylate nonyl phenol acrylate, about 1 to about 10%, by weight; ethoxylate nonyl phenol, about 1 to about 10%, by weight; and/or 2-phenoxyethyl methacrylate esters, about 1 to about 10%, by weight.

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17. The method of claim 15, in which the resin material is exposed to light in the range of about 368 to about 580 nm.

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18. The method of claim 17, in which the resin material is cured for a period of time of about two and a half minutes or less.

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19. The method of claim 15, in which the light passes through a diffusion member before the light passes through and cures the lens forming resin material.

20. The method of claim 19, in which the resin material in the lens forming cavity is rotated about an axis extending perpendicular to the plane of the lens during the curing of the lens forming resin material.

5           21. The method of claim 15, in which the front mold comprises a nickel material coated with a hard carbon surface.

22. The method of claim 15, in which the back mold comprises a transparent glass material.

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23. The method of claim 15, in which the lens forming resin material is exposed to heat or visible and/or UV light for a period of two and a half minutes or less.

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24. The method of claim 15, in which the gasket is removed, exposing the edge of the cured lens material and a force is applied at least a portion of an edge of the front and/or back molds to remove the lens from the front and back molds.

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25. The method of claim 15, in which the resin material further comprises at least one photochromatic dye material.

26. The method of claim 15, in which the resin material further comprises at least one photoinitiator material.

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27. The method of claim 15, in which the resin material further comprises at least one UV stabilizer material.

28. The method of claim 15, in which the resin material further  
30 comprises at least one dye stabilizer material.

29. The method of claim 15, in which the resin material comprises the lens composition for forming photochromatic lens comprises bisphenol A ethoxylate (1 to 4) dimethacrylate, about 70 to 90%, by weight; benzylmethacrylate, about 10 to about 20%, by weight, and one or more of the following stabilizing monomers selected from the group of: trimethylolpropane trimethacrylate, about 1 to about 20%, by weight; isobornyl methacrylate, about 1 to about 20%, by weight; ethoxylate nonylphenol, about 1 to about 20%, by weight; 2-phenoxyethyl methacrylate-esters, about 1 to about 20%, by weight; ethoxylate nonyl phenol acrylate, about 1 to about 20%, by weight; optionally, one or more photochromatic dyes, about .001 to about .0001%, by weight; optionally, one or more UV stabilizers, about 1 to about .1%, by weight; optionally, one or more dye stabilizers, about .1 to .00001%, by weight; optionally, one or more silane materials, about 1 to 5%, by weight; and optionally, one or more photoinitiators, about 1 to about 5%, by weight.

30. The method of claim 15, in which the resin material comprises: bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight; benzylmethacrylate, about 8.58%, by weight; trimethylolpropane trimethacrylate, about 2.6%, by weight; UV stabilizer, about .19%, by weight; Chromtech Blue 475, about .004%, by weight; Chromtech PH 20, about .0096%, by weight; Chromtech PH 8, about .00096%, by weight; silane, about 2.9%, by weight; and photoinitiator, about .18%, by weight.

31. The method of claim 15, in which the resin material comprises: bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight; benzylmethacrylate, about 8.58%, by weight; trimethylolpropane trimethacrylate, about 2.6%, by weight; UV stabilizer,

about .19%, by weight; Chromtech Orange PH-2458, about .004%, by weight; Chromtech PH 20, about .0096%, by weight; Chromtech PH 8, about .00096%, by weight; silane, about 2.9%, by weight; and UV stabilizer, about .18%, by weight.

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32. The method of claim 15, in which the resin material comprises: bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight; benzylmethacrylate, about 8.58%, by weight; ethoxylate nonylphenol, about 2.6%, by weight; UV stabilizer, about .19%, by weight; Chromtech Purple 293, about .004%, by weight; Chromtech PH 20, about .0096%, by weight; Chromtech PH 8, about .00096%, by weight; silane, about 2.9%, by weight; and photoinitiator, about .18%, by weight.

33. The method of claim 14, in which the resin material comprises: bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight; benzylmethacrylate, about 8.58%, by weight; ethoxylate nonylphenol, about 12.6%, by weight; UV stabilizer, about .19%, by weight; Chromtech Yellow 339, about .004%, by weight; Chromtech PH 20, about .0096%, by weight; Chromtech PH 8, about .00096%, by weight; silane, about 2.9%, by weight; and photoinitiator, about .18%, by weight.

34. The method of claim 14, in which the resin material comprises: bisphenol A ethoxylate (1 to 4) dimethacrylate, about 85.7%, by weight; benzylmethacrylate, about 8.58%, by weight; UV stabilizer, about .19%, by weight; Chromtech Green 572, about .002%, by weight; Chromtech Blue 475, about .002%, by weight; Chromtech PH 20, about .0096%, by weight; Chromtech PH 8, about .00096%, by



Year	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
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